

Recommended Welding Parameters

Current	Voltage	Wire Diameter
140-260 A	20-29 V	1.2 mm (0.047 in.)
180-210 A	22-26 V	1.2 mm (0.047 in.)
125-150 A	20-24 V	1.2 mm (0.047 in.)
170-240 A	24-28 V	1.2 mm (0.047 in.)
190-350 A	25-30 V	1.6 mm (1/16 in.)
240-300 A	22-27 V	1.6 mm (1/16 in.)
190-260 A	21-26 V	1.6 mm (1/16 in.)
290-340 A	26-30 V	1.6 mm (1/16 in.)
260-310 A	22-27 V	1.6 mm (1/16 in.)
280-320 A	24-28 V	1.6 mm (1/16 in.)
60-170 A	13-24 V	0.8 mm (0.030 in.)
100-130 A	18-22 V	0.8 mm (0.030 in.)
125-150 A	20-24 V	0.8 mm (0.030 in.)
90-210 A	15-26 V	1.0 mm (0.040 in.)
280-400 A	26-31 V	2.4 mm (3/32 in.)
280-360 A	26-30 V	2.4 mm (3/32 in.)
300-400 A	26-32 V	2.4 mm (3/32 in.)
60-170 A	13-24 V	0.9 mm (0.035 in.)
125-150 A	20-24 V	0.9 mm (0.035 in.)
85-120 A	20-23 V	0.9 mm (0.035 in.)
170-190 A	21-26 V	0.9 mm (0.035 in.)
-		2.0 mm (5/64 in.)

Classifications

Wire Electrode	SFA/AWS A5.10 : ER5356 EN ISO 18273 : S Al 5356 (AlMg5Cr(A))
Classifications	JIS Z 3232 : A53556

Consumable Characteristics

Alloy Type	AlMg 5
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Typical Weld Metal Analysis %

Typical Wire Composition %							
Al	Cr	Cu	Fe	Mg	Mn	Si	Zn
94.560 %	0.12 %	0.01 %	0.13 %	4.9 %	0.13 %	0.05 %	0.01 %